

Work Order ID 63616

November 5, 2010 7:20:18 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 11/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/26/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CLDate: 10/11/05 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8.10.12/15for BG 10-12-15

110

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 12873

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B m115844CL 10/11/05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63616

November 5, 2010 7:20:18 AM

Page 2

Item ID: D350-604-041

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Item Name: Rear Locker Extender

Start Date: 11/05/10 Start Qty: 1.00

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Required Date: 11/26/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



Packaging

Receive & Inspect for Damage & Mat'l Certs
Packaging

0.00

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

11/14/13 (1)

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

8/12/14

(X)

140



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

10/12/14 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63616

November 5, 2010 7:20:18 AM

Page 3

Item ID: D350-604-041

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Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 11/05/10 Start Qty: 1.00

Cust Item ID:

Required Date: 11/26/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/15

10/12/16

MF
10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 5, 2010 7:20:17 AM

Page 1

Work Order ID: 63616



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 11/05/10

Required Date: 11/26/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2600-6		Purchased	No			110	Each	133.0000	4	4			
--------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--



Camlock Stud

Location	Loc Qty	Loc Code
ST381	133	
114238	4	
114355	4	
115502	4	
115814	52	
115987	69	

D350-604-041P		Purchased	No			120	Each	1.0000	1	1			
---------------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--



Rear Locker Extender

Location	Loc Qty	Loc Code
ST	1	
62259	1	

D2268		Manufactured	No			140	Each	13.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Decal

Location	Loc Qty	Loc Code
ST010	13	
60213	3	
62243	10	



4 C21011105

B63616 12/2/14 sl

12/2/14 sl

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

November 5, 2010 7:20:17 AM

Work Order ID: 63616



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 11/05/10

Required Date: 11/26/10

Start Qty: 1.00

Required Qty: 1.00

D2269

Manufactured No

140

Each

18.0000

1



Decal

11/12/10 sp

Location

Loc Qty

Loc Code

ST010

18

62244

8

63338

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4
REF FAA STC: SR00463NY

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

WAS:

4	2600-4	CAMLOC STUD
---	--------	-------------

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63616
621011105

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>92</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>92</u>		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>NIA</u>	DSI 9470	SHEET 1 OF 1
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE	

RELEASED
02.04.03

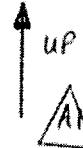
REAR LOCKER EXTENDER (D2273)

RETAINING WASHER
2600-LW (4)



INSTALL D2728-1 DECAL
IN DEPRESSION ON INSIDE
BACK WALL

CAMLOCK STUD
2600-4 (4)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63414

DECAL (D2268)
TOTAL WEIGHT IN THIS COMPARTMENT
NOT TO EXCEED 15 LBS (7 KGS)

D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



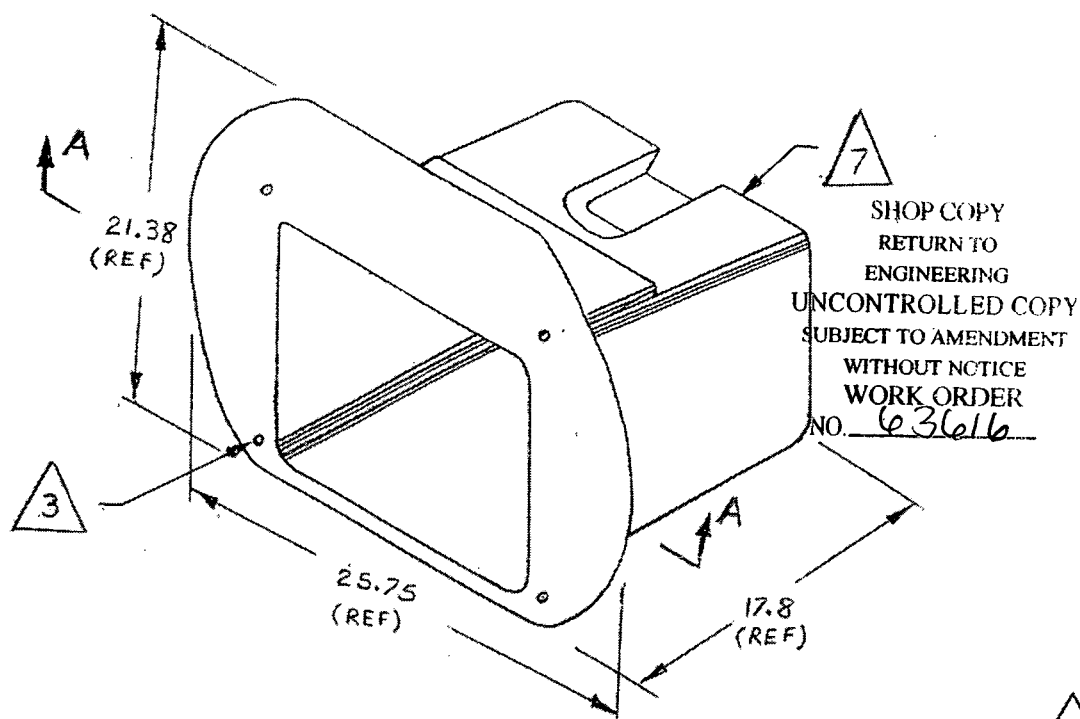
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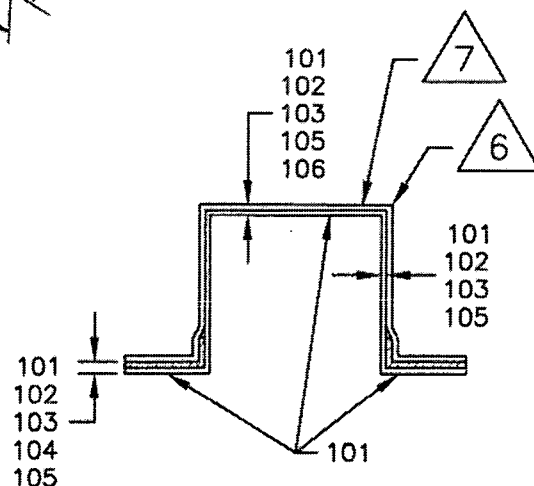
DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE 02.04.01	TITLE 350 REAR LOCKER EXTENDER		SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED
02.04.03 *[Signature]*



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	36350
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Point de départ		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
10/12/2010	05/11/2010	15951	Chantal Lavoie	PO12873			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Item 0001 Rear Locker Extender D350-604-041P B63614 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B63614 29491			
1	0	1	DKC134-0003	Item 0002 Rear Locker Extender D350-604-041P B63615 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B63615 29492			
1	0	1	DKC134-0003	Item 0003 Rear Locker Extender D350-604-041P B63616 U de M : Each Référence <u>DKA362-0004</u> DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> <u>No. lot</u> B63616 30406 8 10/12/14			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: _____

Quality department

AQ-357



Date: Lundi, 2010-11-22 18:09:37
Utilisateur: Pascal Carignan

Feuille de Procédé

OLMG ✓

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 30406	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-11-22 No. B.V. :	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2010-11-29 Qté: 1 Udm: UNITE
Job précédente	: 29492		

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041

Process Sheet Rév.: 01 Mise en page selon nouvelle forme.
Déplacer cette seq. 12 en avant de la seq. 6. Ajouter sablage dans
seq. Trimage.

B63616

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: _____ Sceau: _____

2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-29020-1

3.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

4.0 AC0747 Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 24 NOV 10 Sceau: _____



Date: Lundi, 2010-11-22 18:09:38
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30406

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon IF134-0003 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% d'acétone.

Date: 29/11/10 Sceau:



7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 29/11/10 Sceau:



8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
-----	---------	---

Commentaire Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-29179-1

9.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentaire Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-28776-2

11.0	AMB0213	WR1850 Roving 18oz. x 50"
------	---------	---------------------------

Commentaire Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot:

1-22302-1

12.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentaire Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 23% Température: 70°F Heure:

Date: Lundi, 2010-11-22 18:09:38
Utilisateur: Pascal Carignan

Feuille de Procédé



Client: DART US DART AEROSPACE LTD
Numéro Job: 30406

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

Quantité: 1 Date: 30/11/10 Sceau:  

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-29179-1

14.0 AMB0286 Catalyst N° DDM-9


Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

15.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.


Quantité: 1 Date: 30-11-10 Sceau: 

16.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1 Date: 1-12-10 Sceau: 


17.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1 Date: 7/12/10 Sceau: 

18.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-28050-2

Date: Lundi, 2010-11-22 18:09:38
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30406

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
19.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-28382-1

20.0	PRIMER	Application primer
------	--------	--------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 9 dec 10 Sceau:  N° fiche de Mélange: N/A

21.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
------	---------	--

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: _____

22.0	AAC0682	Washer 2600-LW (1127700)
------	---------	--------------------------

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: _____

23.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasquer la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1 Date: 10/12/10 Sceau: 

24.0	IDENTIFICATION	Identification à encre indélébile
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

B.C. OK IF134-0005
Faire l'identification de la pièce selon IF134-0005

IG 0055



B.L. 6/12/2010

Quantité: 1 Date: 10 dec 2010 Sceau: 

25.0	INSPIC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 10 DEC 10 Sceau: 

Date: Lundi, 2010-11-22 18:09:38
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30406

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1 Date: 10 Dec 2010 Sceau: L.B.

fab. 10 Dec 2010
Job 30406